

Doors by **RODDIS**

Guarantee :

Doors made to Roddis specifications are unqualifiedly guaranteed for two years against defective material and workmanship.

Roddis Lumber and Veneer Company

RODDIS LUMBER AND VENEER COMPANY

Marshfield, Wisconsin



RODDIS LUMBER and VENEER COMPANY

MARSHFIELD, WIS.

EXPERIENCE • FACILITIES • RESPONSIBILITY

EXPERIENCE—Established in 1890, Roddis Lumber and Veneer Company has, during its forty-seven (47) years of door-building experience, achieved an enviable reputation for high quality. The Company has, during this period, made doors of every conceivable type of construction and has pioneered in the development of many outstanding improvements, resulting in today's Roddis Guaranteed, Time-Tested, Standard Construction which permits unrestricted latitude so far as the architectural design is concerned.

FACILITIES—Except for certain foreign cabinet-wood logs, Roddis controls all operations from forest to finished product. Roddis experts and woodsmen select trees from Roddis owned timber land, fell them, and cut the logs. Roddis railroads haul the logs to Roddis mills where all lumber is sawn and fully cured for years before cutting into door stock. Roddis mills, manned by experienced tradesmen, are equipped with every modern facility to produce the highest quality veneered doors and plywood.

RODDIS LUMBER & VENEER CO. GUARANTEE BOND

Know All Men By These Presents, That the Roddis Lumber & Veneer Co. with office in the city of Marshfield in the State of Wisconsin, is held and firmly bound unto _____ (his) (their) heirs or assigns in the penal sum of _____ (\$_____.) for the payment of which it binds itself, its successors and assigns.

The Condition of the Above Obligation is Such That, Whereas the said _____ has purchased of the Roddis Lumber & Veneer Co. _____ doors for _____ of _____, said doors manufactured by the Roddis Lumber & Veneer Co. of Marshfield, Wis., and in consideration of such purchase said company guarantees the said doors for two years from date of delivery against defective material and workmanship, and agrees to repair at its own expense any such defects that may be found in such doors during said period of two years, or furnish new doors to replace such defective doors of which it may have notice within said time.

Now, Therefore, If the said Roddis Lumber & Veneer Co. shall properly repair any defects in material and workmanship that may be found in the said doors or any of them within two years from date of delivery, or shall furnish new doors for any defective doors of which it may be notified before the expiration of the said two years, then this obligation shall be void, otherwise to remain in full force.

In Witness Whereof: The said Roddis Lumber & Veneer Co. has caused these presents to be signed by its president on this _____ day of _____ 193____.

RODDIS LUMBER & VENEER CO.

Per _____ President

Attest: _____

RESPONSIBILITY—The Roddis Lumber and Veneer Company will assume full responsibility for its products and will furnish its Guarantee Bond where the construction of its doors follows its recommended standards as hereinafter established. This in no sense need be construed as conflicting with the architect's prerogative of design control.

SERVICE—Roddis distributors and experienced representatives are located in all principal cities of the United States. Complete information regarding Roddis products, samples, detail drawings, consultation and advice relative to unusual problems and comparative cost data will be furnished promptly when requested.

IDENTIFICATION — Every Guaranteed Roddis Door is distinctly and permanently marked for identification with the Roddis red, white, and blue hard wood dowel inserted in the edge—a further evidence of Roddis responsibility.



• RODDISCRAFT DOORS •

WATERPROOF FLUSH VENEER CONSTRUCTION

RADICALLY NEW PROCESS OF FABRICATION — Flush door construction has been improved from time to time during the past fifty years. The first flush doors produced were made with animal or vegetable glue. About twenty years ago Roddis Lumber & Veneer Company perfected a waterproof glue for fabricating U. S. Government aircraft plywood and pioneered in the use of this "wet" glue for flush doors—a forward step in improved door construction.

Now, after twenty years' experience with waterproof adhesives, this company is able to announce the perfection of a waterproof "dry glue" film that is the greatest improvement in flush door construction in half a century. The bond is produced by the simultaneous application of heat and pressure without introducing water into the dry lumber and veneers and is known as the Roddiscraft process. The kiln dried, glued-up door core, crossbandings, and face veneers are assembled with thin sheets of dry glue laid between core, crossbandings, and face veneers. The entire assembly is placed in a hot plate press where, under tremendous pressure and heat, the glue films are fused and the five separate plies are literally welded into one solid block with four permanently waterproof films over the entire door area. No moisture has been added to the door, and no moisture can penetrate the waterproof glue film after completion.

THE GLUE—PERMANENTLY WATERPROOF — The "dry-glue" process has proven its practicability and permanently waterproof qualities in Europe over a period of ten years. Only the cost of foreign-made, patented equipment has prevented its more general use in America. It is inert to water or any known chemical solution.

THE CORE—Roddis Cores are of selected, narrow pine strip-blocks **all running in one direction**, waterproof-glued together under pressure, and scientifically kiln-dried to the proper moisture content—a time-tested Roddis Standard Construction.

THE CROSSBANDING — Roddis hardwood crossbanding, $\frac{1}{8}$ inch thick, is cut from Roddis logs in Roddis veneer mills, carefully selected for quality, strength, freedom from imperfections, and machine dried to the proper moisture content before use.

THE FACE VENEERS—Most face veneers for Roddis Doors are cut from specially selected Roddis logs in Roddis veneer mills. For foreign veneers, selected flitches are purchased and the veneers carefully matched in the Roddis mills. All face veneers are scientifically cured and machine dried.

WHY STANDARD THICKNESS FACE VENEERS ARE BEST—Solely in the interest of better construction backed by its forty-six years of door-building experience, the Roddis Company has incorporated standard thickness face veneers (as opposed to $\frac{1}{8}$ inch and thicker veneers) as an important element of its Standard Construction carrying its unqualified guarantee. The following factors are salutary: (1) The thickness of the face veneers in no way affects the appearance or limits the finish; (2) The "dry-glue" fabrication so permanently and inseparably bonds the face veneers to the tough hard wood crossbanding that they function as a unit, resulting in a strong, durable door surface; (3) Obviously the less moisture absorbing wood exposed outside the protective waterproof glue film the better; (4) Due to the reduced wood thickness, the edges of matched or joining veneers will not shrink, swell or cup; (5) More perfect book-leaf matching can be secured with Standard Thickness face veneers than with thicker veneers.

RODDIS FINISHING SERVICE—For more than thirty years the Roddis Company has maintained a high quality finishing department for the convenience of Roddis Woodwork customers. This department is

equipped with modern machinery, handled by experts competent to match perfectly the architect's samples. Doors which are dry and properly cleaned and prepared at the Roddis plant for finish should always be protected against moisture absorption and dirt by priming, if to be painted, or by staining, filling, and shellacing before they leave the factory. The work of final painter's finish over the priming coat and varnishing over the shellac should invariably be done at the job. In the case of inlaid doors which are stained, the staining should always be done before inlaying to assure clear, well defined lines. The cost of this protective, preliminary priming and finishing is decidedly moderate.



MAKE YOUR OWN TEST

THE COMPANY WILL FURNISH A SECTION OF RODDISCRAFT FLUSH VENEER DOOR CONSTRUCTION TO ANY ARCHITECT TO DEMONSTRATE ITS PERMANENT WATERPROOF QUALITIES. IMMERSE THE SECTION FOR ANY LENGTH OF TIME IN A RECEPTACLE CONTAINING WATER.

• RODDIS FLUSH VENEER DOORS •

Outstanding Features

WATERPROOF CONSTRUCTION—Roddiss five-ply flush veneer doors (core, crossbandings, and face veneers) when made in accordance with RODDIS STANDARD CONSTRUCTION are permanently waterproof and resistant to decay, mildew or fungi. The pine cores are fabricated under pressure with special casein waterproof glue. The exposed top and bottom edges of the soft wood core as well as the sides are sealed with hard wood edge strips. Crossbandings and face veneers are glued to both sides of the kiln dried core by the "dry-glue" process, forming two complete, permanently waterproof glue films over the entire area of each face.

STAVED CORES—The cores are made up from narrow, uniform width, clear pine strips of varying lengths assembled with the grain all running in the same direction (from top to bottom of the door). Hard wood edge strips are provided at top, bottom, and two sides—an exclusive Roddis feature. Core strips and edge strips are glued together under pressure with casein waterproof glue. After gluing, the cores are kiln dried, seasoned to atmospheric conditions and planed smooth to receive the crossbanding.

CROSSBANDINGS—Selected Roddis hard wood crossbandings, $\frac{1}{16}$ inch thick, laid with the grain run-

ning at right angles to the core grain, are glued to both sides of the core by the Roddiscraft waterproof "dry-glue" method (pressure and heat).

FACE VENEERS—Standard thickness face veneers (see below), laid with the grain running normally at right angles to the grain of the crossbandings (from top to bottom of the door), are glued over the crossbandings by the Roddiscraft waterproof "dry-glue" method. Face veneers may be of domestic or foreign woods; sliced or rotary cut; plain or figured; matched or in combination patterns; with or without inlays at the designer's discretion. Samples of obtainable plain and figured woods will be submitted for selection.

INTERIOR AND EXTERIOR DOORS—The Roddis Standard Construction 5-ply flush veneer doors as described above are adapted for both exterior and interior use. No special construction is required for exterior exposure to moisture or sun.

TESTS—The Company prefers that the architect conduct his own tests as evidence of the waterproof quality of the Roddis Construction. A sample door section will be sent for this purpose on request. See illustration of suggested water test on page 2.

Specifications

INTERIOR and EXTERIOR FLUSH VENEER DOORS

Note: Notes are explanatory or advisory only and should not be included in the specifications.

Note: Select and include only those clauses which apply. Words in bracketed bold face type are selective.

(1) **GENERAL**—All doors (so indicated on door schedules) shall be 5-ply Flush Veneer Doors made by Roddis Lumber and Veneer Company, Marshfield, Wisconsin.

(1a) Doors shall be constructed in strict accordance with Roddiscraft Standard Construction covered by their two-year Guarantee Bond.

(1b) Doors shall be of sizes and thicknesses called for (in door schedules) (on plans).

(2) **CORES**—Cores shall be made of clear pine strip-blocks of uniform width assembled with the grain running parallel and vertically (from top to bottom of door). Cores shall be nailed on all four edges with $\frac{3}{4}$ inch wide hard wood strips. Those on side edges to match face veneer. The whole assembly shall be glued under pressure with casein waterproof glue and thoroughly kiln dried, seasoned and planed smooth.

(3) **CROSSBANDINGS**—Crossbandings of $\frac{1}{16}$ inch thick, thoroughly kiln dried, hard wood veneer shall be laid with the grain at right angles to that of the core and glued by the water-

proof "dry-glue" process (pressure and heat) to both sides of the core.

(4) **FACE VENEERS**—Thoroughly kiln dried, standard thickness, (specify wood) face veneers (of woods hereinafter specified), laid with the grain at right angles to that of the crossbandings, shall be glued by the waterproof "dry-glue" process (pressure and heat) to both faces of the door and belt sanded smooth.

(4a) Face veneers shall be as follows:

Note: Here describe any special requirements of species, figure, pattern, inlays, etc. If more than one type is required, specify each separately and locate here or by reference to door schedules or special detail drawings.

(5) **GLAZING**—(Not by door manufacturer)—All glass for glazed doors shall be (specify).

(5a) Glazing shall be accomplished (in accordance with details), using removable wood glazing mouldings set in lead or varnish to seal against moisture absorption.

(5b) Where called for (on door schedules) (on plans), doors shall be equipped with (specify grade and type) (specify size) mirrors in accordance with details.

(5) **FINISHING**—

Note: Here specify preliminary finishing to be applied by the door manufacturer. See page 2.

STANDARD FACE VENEERS

Standard thickness of face veneers before sanding: Rotary cut or Plain Sawn Birch, Oak, or Gum, $\frac{1}{20}$ in.; White Pine, $\frac{1}{16}$ in.; Quartered Oak, $\frac{1}{20}$ in.; Quartered Gum, $\frac{1}{24}$ in.; Sliced Walnut, Mahogany, or foreign woods, $\frac{1}{28}$ in.

RODDIS FLUSH VENEER DOORS

Typical Designs



Prima Vera



Avodire



Roddis Construction



Walnut



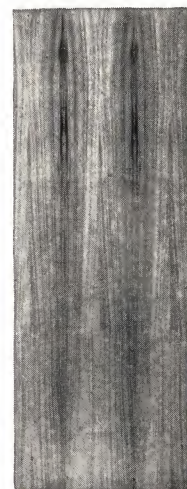
Curly Birch



Red Birch



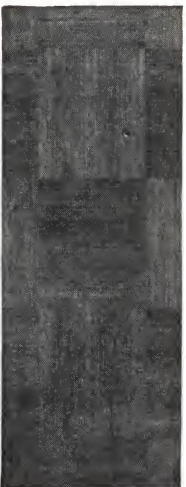
Qtd. Gum



Tigerwood



Mahogany



Qtd. Walnut



Rotary Ash



White Oak



Rotary Elm

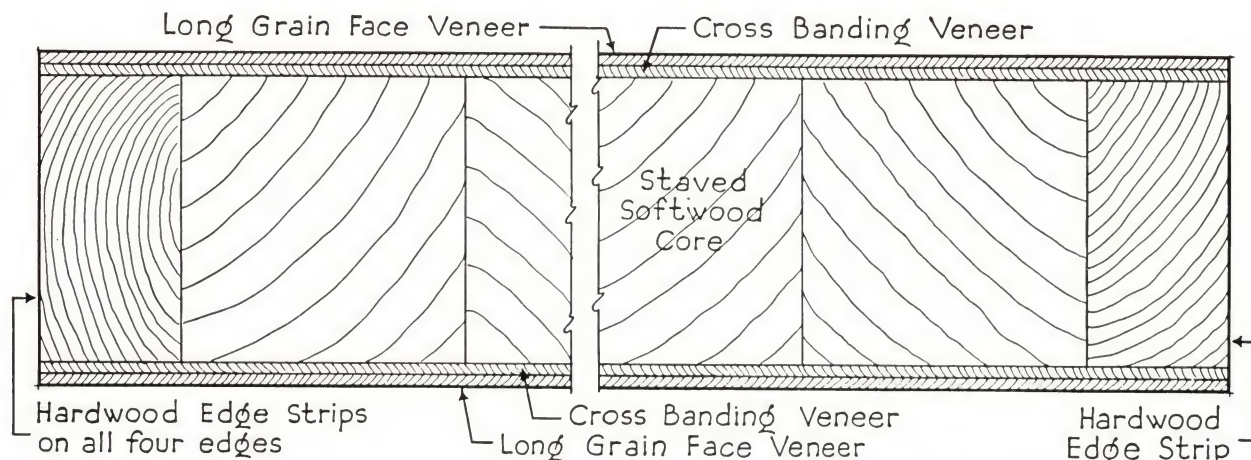


Oriental Wood

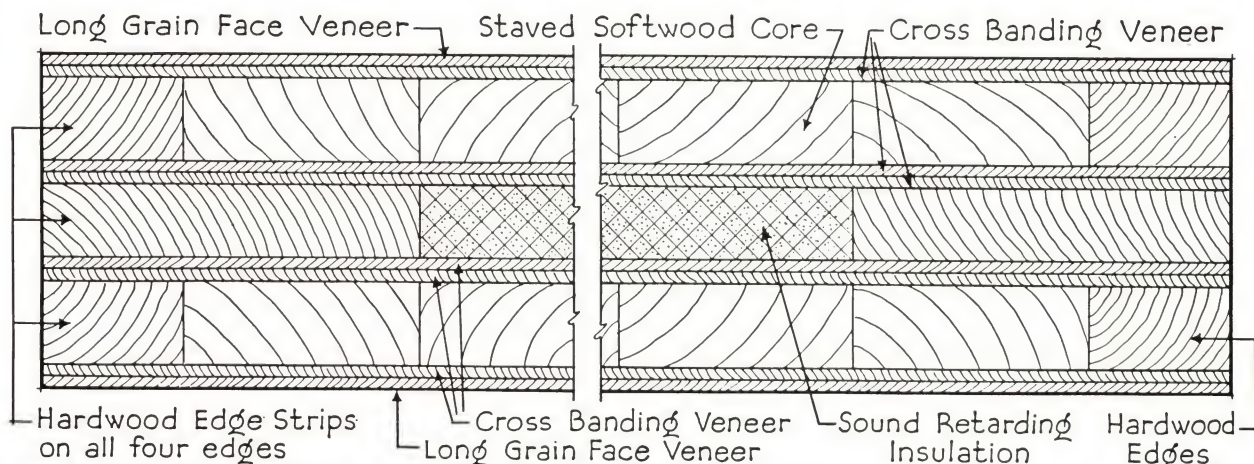


Rift Sw. Oak

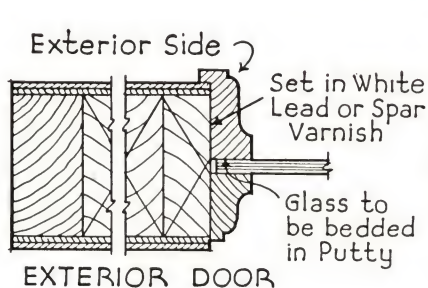
DETAILS OF FLUSH DOORS



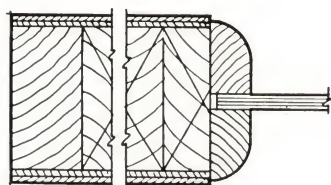
FULL SIZE DETAIL OF FLUSH DOOR CONSTRUCTION



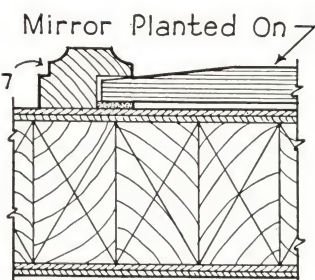
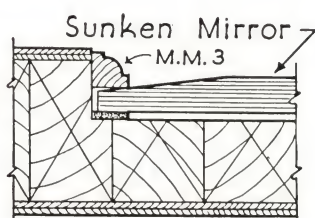
FULL SIZE DETAIL OF SOUND RESISTANT DOOR CONSTRUCTION



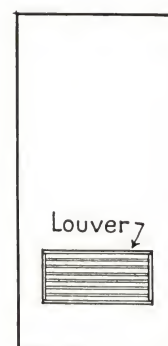
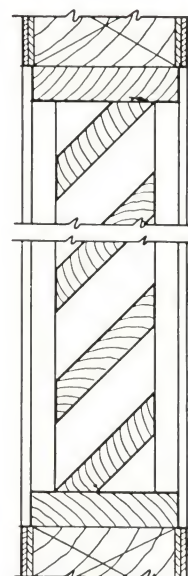
EXTERIOR DOOR



INTERIOR DOOR
LIGHT OPENING
DETAILS



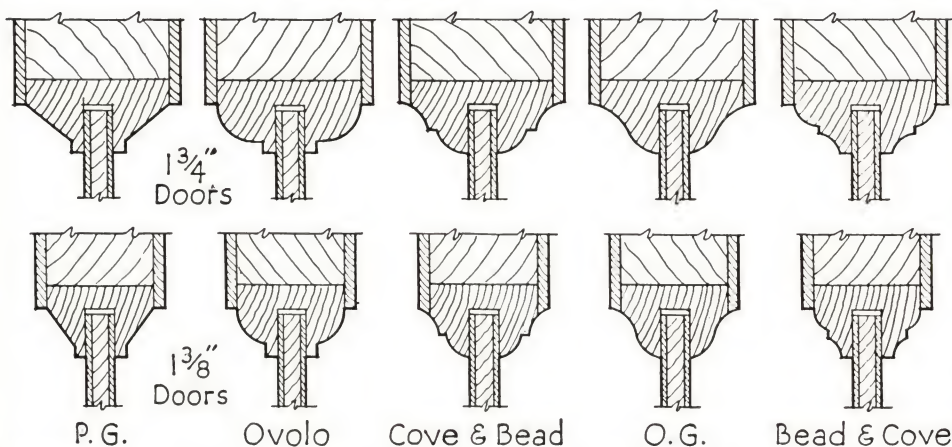
MIRROR DOOR
DETAILS



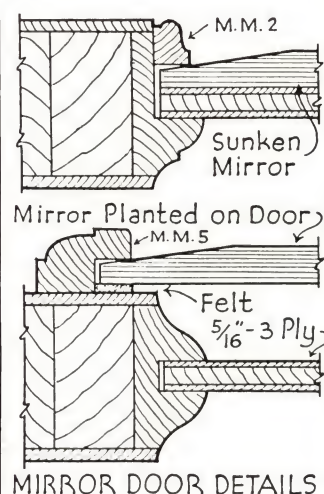
Elevation of Door
Section

STANDARD
LOUVER
CONSTRUCTION

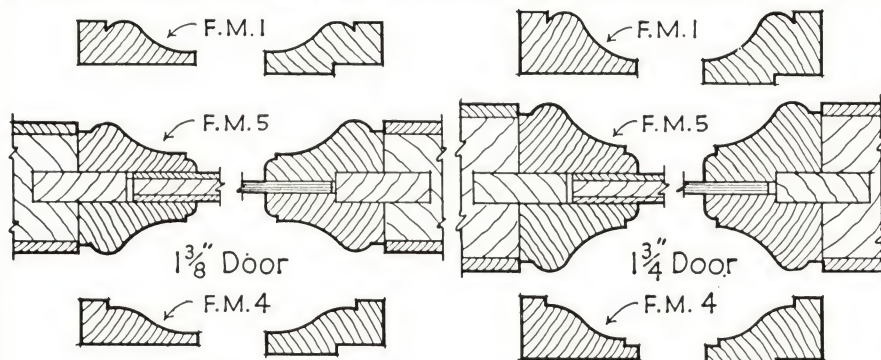
DETAILS OF PANEL DOORS



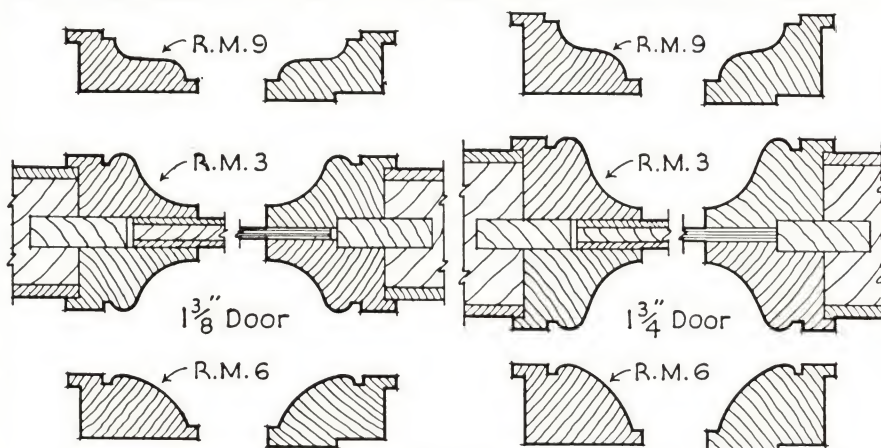
STANDARD SOLID STICKING FOR PANEL DOORS



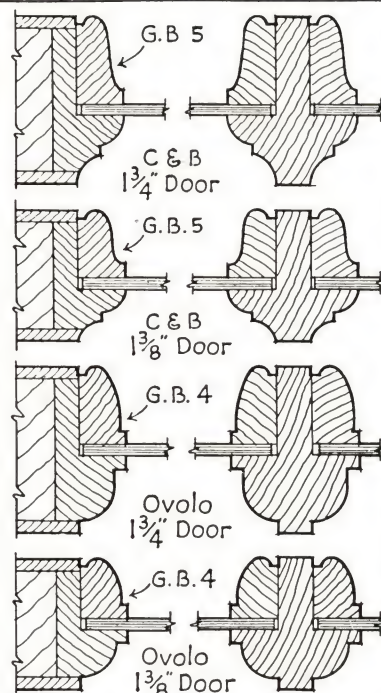
MIRROR DOOR DETAILS



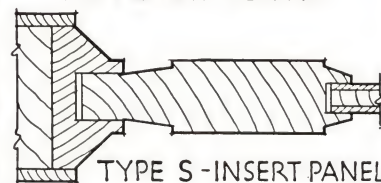
SUGGESTED FLUSH MOULDING DETAILS



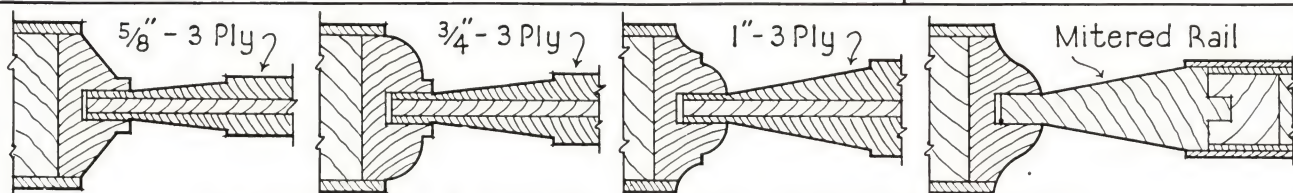
SUGGESTED RAISED MOULDING DETAILS



STANDARD SOLID STICKING FOR SASH DOORS



TYPE S-INSERT PANEL



STANDARD RAISED PANEL CONSTRUCTION

• RODDIS STILE and RAIL DOORS •

Outstanding Features

CUSTOM BUILT—Roddis Stile and Rail Doors, where desired, are custom built accurately following the architect's special detail. Stile and rail dimensions, panel arrangement and detail, and panel mouldings may all vary from standard. Only major construction features, which in no way affect the design, need follow Roddis Standard Construction to carry the Roddis two-year Guarantee. Obviously, the use of standard dimensions, panel thicknesses, and moulding profiles will effect economies and hasten deliveries.

STILE AND RAIL CONSTRUCTION—Stiles and Rails are 3-ply construction. Cores are identical in material and construction to those described on page 3 for flush veneer doors. The exposed door edges, top, bottom and two sides are edged with hard wood strips (including top and bottom of side stiles on exterior doors). Since there is no crossbanding, $\frac{1}{8}$ inch thick face veneers are glued directly over the core (by the Roddiscraft waterproof "dry-glue" process on exterior doors only). Stiles and rails are doweled together.

PANELS—Standard interior door panels are flat 3-ply construction, $\frac{5}{16}$ inch thick. Those for exterior doors are flat 5-ply, $\frac{3}{8}$ inch thick. Face veneers for both interior and exterior doors are of standard thicknesses. Special laminated panels of other than standard thicknesses, either flat or raised, are obtainable.

VENEERS—The same choice of domestic or foreign veneers as described on page 3 for flush veneer doors is obtainable for stile and rail doors.

EXTERIOR DOOR WATERPROOF CONSTRUCTION—Cores for stiles and rails are constructed like those for flush veneer doors. Tops, bottoms, and sides of the doors, including the side stile ends, are sealed with hard wood edging strips. Stile and rail face veneers are applied by the waterproof "dry-glue" method (pressure and heat). Panels are five-ply construction glued by the waterproof "dry-glue" process. This recommended waterproof construction costs but slightly more than the customary construction.

Specifications

INTERIOR and EXTERIOR STILE and RAIL DOORS

Note: Notes are explanatory or advisory only and should not be included in the specifications.

Note: Select and include only those clauses which apply. Words in bracketed bold face type are selective.

(1) **GENERAL**—All doors (so indicated on door schedules) shall be Stile and Rail Doors made by Roddis Lumber and Veneer Company, Marshfield, Wisconsin.

(1a) Doors shall be constructed in strict accordance with Roddis Standard Construction covered by their two-year Guarantee Bond.

(1b) Doors shall be of sizes, thickness, and design called for (in door schedules) (on plans) (and) (as detailed).

(1c) All doors shall be belt sanded smooth for finish.

(2) **STILES AND RAILS**—Cores shall be of clear pine strip-blocks assembled with the grain running parallel and lengthwise of the member. Outside core edges shall be edged with $\frac{3}{4}$ inch wide hard wood strips, matching face veneer wood, on door side stiles (including tops and bottoms on exterior doors) and on top and bottom rails. The whole core assembly shall be glued under pressure (with casein waterproof glue for exterior doors) and thoroughly kiln dried and planed smooth.

(2a) Where the panel and moulding design require it, the panel edge of stiles and rails shall be trimmed with face veneer wood.

(2b) Face veneers shall be glued (by the waterproof "dry-glue" process on exterior doors) to both sides of the core.

(2c) For flush or raised moulded doors all stiles and rails shall be planed and furnished with hard wood panel splines glued to the core construction.

(2d) All stiles and rails shall be set together in glue with 9/16 inch hard wood dowels spaced approximately 3 inches apart on centers.

(3) **PANELS**—(Except for the cores of Staved-core panels) all flat panels for exterior doors shall be fabricated by the waterproof "dry-glue" process, the grain of alternate plies of veneer crossing in opposite directions.

(3a) Interior door panels shall be flat 3-ply, $\frac{5}{16}$ inch thick.

(3b) Exterior door panels shall be flat 5-ply, $\frac{3}{8}$ inch thick.

(3c) Panels shall be constructed as follows:

Note: Here describe and locate special flat or raised panel construction at variance with standards as above in (3a) or (3b).

(3d) All panels shall be loose and in no way attached to stiles, rails, or mouldings.

(4) **VENEERS**—Concealed laminated panel veneers shall be of selected, kiln dried hard wood.

Face veneers shall be thoroughly kiln dried of (woods called for in door schedules) (woods specified hereinafter) (specify wood), $\frac{1}{8}$ inch thick (before sanding) for stiles and rails and standard thickness for flat panels.

(4a) Face Veneers shall be as follows:

Note: Here specify and locate the various veneers selected. For standard thicknesses see page 3.

(5) **PANEL MOULDINGS**—Panel mouldings shall be (solid stuck) (flush) (raised) of wood (to match stile and rail face veneers) (specify) (made in accordance with details).

(5a) Panel moulding shall be glued and bradded to the stiles and rails only—not to the panels.

(6) **GLAZING**—**Note:** See paragraph (5), page 3.

(7) **FINISHING**—**Note:** See paragraph (6), page 3.

RODDIS STILE and RAIL DOORS

Typical Designs



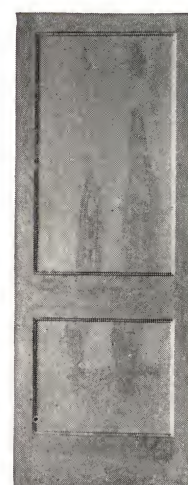
Type A



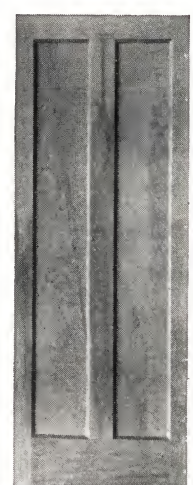
Type S



Type L—R.P.—F.M.



Type B



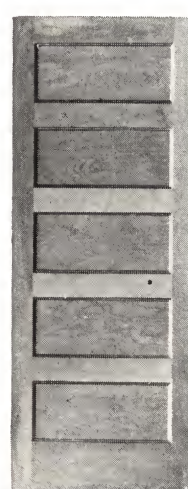
Type G



Type D



Type I



Type F



Type L



Type M



Type M-I



Type O



Type B-B

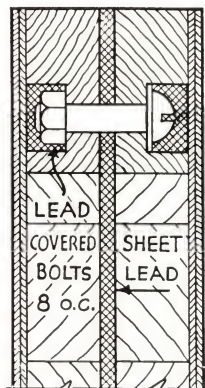
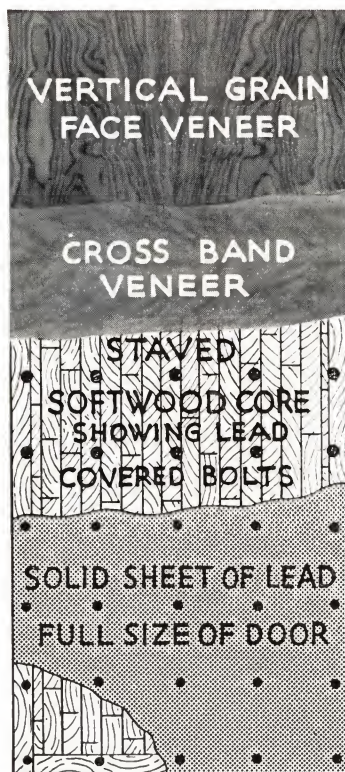


Type O-O



A-A 15 Lt.

RODDIS X-RAY DOOR

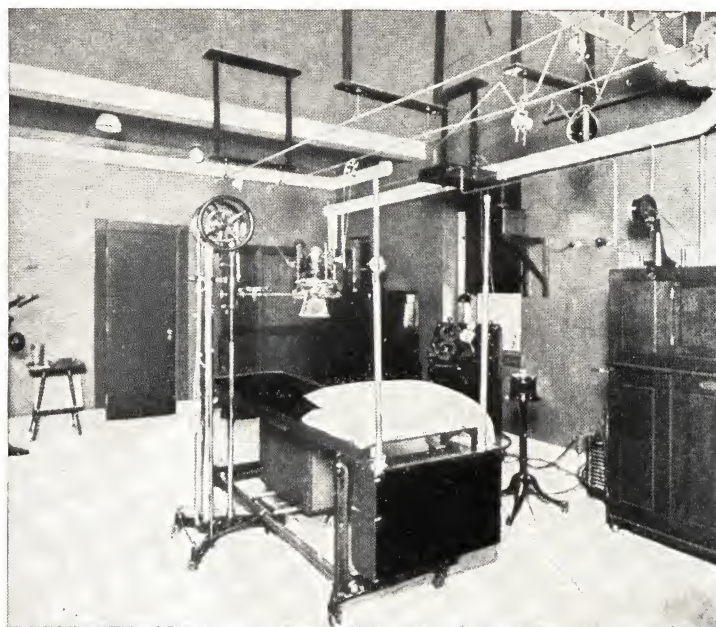


The Roddis X-Ray Door is lighter and less cumbersome than the usual door of this type. In appearance and finish it matches the standard Roddis Flush Veneer Door.

The Roddis X-Ray Door was designed for the Roddis Company by a prominent architect specializing in hospital buildings. This

door functions like other X-Ray doors but is not as heavy, awkward, and unsightly in appearance as the usual door of this type.

The Roddis X-Ray Door is equipped with a thick, continuous sheet of lead set midway between a divided wood core. The lead is securely held in position with counter-sunk, lead-covered through bolts, spaced 8 inches on center. Otherwise the Roddis X-Ray Door



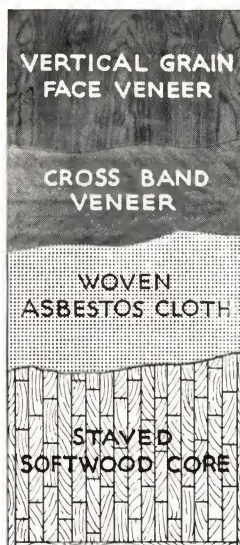
is identical in all respects with the standard Roddis Flush Veneer Door described in detail on page 3 and carries the Roddis two-year Guarantee. The divided pine core, edged on all sides with hard wood edging strips, fabricated with waterproof glue, is the same. Crossbandings and face veneers secured together and to the core by the waterproof "dry-glue" process are the same. Consequently, the X-Ray doors match in appearance and finish the doors used elsewhere in adjoining parts of the building.

The Roddis X-Ray Door has been used in hospitals throughout the United States selected for its efficiency and outstanding construction and appearance features by discriminating architects.

RODDIS FIRE RESISTANT FLUSH DOORS

PROTEX FLUSH DOORS—Roddis Protex Flush Doors are built to order. Over each side of the soft wood core is applied a sheet of woven asbestos cloth. Over these fire-resistant membranes are applied the Roddis standard crossbandings and face veneers. The door construction, other than the introduction of the two layers of woven asbestos cloth between the core and crossbandings, is exactly the same as that described in detail for Roddiscraft Flush Veneer Doors on pages 2 and 3. Their appearance is the same, they take the same finish, and they have the same waterproof qualities. Consequently, they are covered by the same Roddis two-year Guarantee as shown on page 1.

FIREPROOFED WOOD CONSTRUCTION—The Building Codes in some cities re-



quire that doors for stairways and similar locations be made of fireproofed wood. In this construction the woven asbestos cloth included in the construction of the Protex Flush Door is not required. Roddis Flush Veneer Doors can be furnished to pass these ordinances with the core, crossbandings, and edge strips treated to make the wood fireproof. Face veneers 1/16 inch thick or thinner, such as are used in Roddiscraft doors, need not be fireproofed. (Where face veneers are over 1/16 inch thick, they too must be fireproofed. They cannot be finished with ordinary stains). The reason these doors are accepted as fireproof is that the chemically treated wood gives off, when heated, a non-inflammable gas which forms a coating excluding the oxygen.

RODDIS WAINSCOTING

CONSTRUCTION—The fabrication of Roddis Wainscoting follows closely the procedure of Roddis veneered doors. The wainscoting is made by the same experienced craftsmen and from the same selected stocks as Flush Doors. Wainscoting may be obtained in any design made to the architect's details in any wood—domestic or foreign, selected for color, figure, and continuity around the room. Flush doors and adjacent wainscoting can be made with face veneers from the same flitch to insure perfectly matched woodwork.

Cores are built up of seasoned, narrow strip-blocks of Northern Basswood or clear Pine, glued together in clamps and allowed to thoroughly season before being planed to accurate thickness. Crossbandings are of selected, machine-dried hardwood veneers. Face and back veneers applied over crossbandings are of standard thickness (see page 3). Unexposed back veneers are of sound reject veneers. The standard thickness for wainscots is $1\frac{3}{8}$ inch.



FABRICATED WAINSCOTING—Roddis experience and facilities are unsurpassed for the production of high quality wainscoting, fabricated and finished at the factory. Trained craftsmen will estimate the cost of the job from the architect's plan and specifications, and, if desired, will recommend and submit samples of face veneers to carry out the architectural design. Each piece of wainscoting can be cut at the factory to exact size and form, rabbeted, beveled, bored for countersunk screw holes, light openings cut in, etc., ready for installation without further fitting at the job.

The backs of panels and all edges can be shellaced to seal the wood against moisture absorption and the faces completely finished except for the final varnish or lacquer coats. This company recommends that the final coat shall always be applied by the painting contractor after the wainscoting is completely installed. Each panel is numbered on the back to show location for continuity of face veneers.

THE GLUE—Roddis wainscoting can be manufactured by either the "wet-glue" process or by the Roddiscraft waterproof "dry-glue" process.

Cores for either process are made up from narrow strips, glued together under pressure with casein waterproof glue. After gluing, the cores are kiln dried, seasoned to atmospheric conditions, and planed smooth to receive the crossbanding. Selected hardwood crossbandings, $\frac{1}{8}$ in. thick, laid with the grain running at right angles to the core grain, are glued to both sides of the core. Standard thickness face veneers (see page 3), laid with the grain running normally at right angles to the grain of the crossbanding, are glued to the crossbanding.

In the "wet-glue" process the crossbandings and face veneers are glued with vegetable or stainless glue, and assembled under pressure in a cold hydraulic press, and the glued up panels are seasoned in a dry kiln. In the Roddiscraft waterproof "dry-glue" process the crossbandings and face veneers are glued with dry glue film and fused together under simultaneous application of heat and pressure.

TO SPECIFY—Follow specifications for Flush Veneer Doors as given on page 3.

Note that cores are railed on only such edges as are exposed. Unexposed back veneers are sound rejects. Exposed face veneers are selected. Standard wainscot thickness is $1\frac{3}{8}$ inch.

Specify that wainscots shall be factory fitted in units easily handled and erected. Specify that wainscots shall be factory finished on faces, backs, and edges except for final coat.

Doors by RODDIS

Guarantee :

Doors made to Roddis specifications are unqualifiedly guaranteed for two years against defective material and workmanship.

Roddis Lumber and Veneer Company

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Marshfield, Wisconsin

